

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015509**Date Inspected:** 07-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Mr. Huang min / Mr. Chen Xi			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Orthotropic Box Girder( OBG)		

**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**BAY- 3**

Submerged Arc Welding (SAW) of weld joint LD3025-001-004. Welder is identified as 053748. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.Refer the attached photo for reference.

**BAY- 6**

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06143.

**Magnetic Particle Testing (MT)**

This QA performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The members are identified as OBG Bottom Panel weld Component. MT performed on weld repaired area. Total number of welds MT Tested: 01 No. The

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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weld designations are review as follows:

1. BP3044-001-028.

Signed off the following green tag:

1. 13283.

This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of weld joint WJF-0-106. Welder is identified as 215083. ZPMC Quality Control (QC) is identified as Mr. Zhao Jian Hang. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112.

Submerged Arc Welding (SAW) of weld joint WJF-0-188. Welder is identified as 053748. ZPMC Quality Control (QC) is identified as Mr. Zhao Jian Hang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-3221-TC-U4a-S-1.

ZPMC QC Certified Welding Inspector Mr. Huang min was performing Visual Testing for the welds located on Bottom Panel identified as BP3066-001.Refer attached photos for additional details.

BAY- 7

SMAW Tack welding of weld joint EP3013-001-009/010. Welder is identified as 049485. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112.

Flux Cored Arc Welding (FCAW) of weld joint BP3038-001-001/002. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint BP3038-001-005/006. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint BP3038-001-009/010. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

ZPMC Personnel performing Heat Straightening for the Bottom BP3058A.Heat straightening was being performed appeared to comply with the Applicable HSR Repot# HSR1 (B)-8730 .ZPMC Quality Control (QC) is identified as Mr. Xia Yong Zheng.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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documents.



## Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhu,Surendra
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall,Steven
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QA Reviewer
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